

Date: Sunday, 12/4/2005 12:44:42 PM
 User: Linda Lacelle

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services Drawing Name : HIGH GEAR SKIDTUBE ASSEMBLY 206 A/B
 Job Number : 25086A
 Estimate Number : 10163
 P.O. Number : N/A Part Number : D206642241
 This Issue : 12/4/2005 S.O. No. : N/A Drawing Number : D2650 REV D1
 Prsht Rev. : NC Project Number : N/A
 First Issue : N/A Type : LANDING GEAR Drawing Revision : D1
 Previous Run : 25085A Material : N/A
 Written By : ~~HA~~ SEE COMMENT REBU Due Date : 1/20/2006 Qty: 1 Um: Each
 Checked & Approved By : SEE ABOVE DATE & USE
 Comment : Est Rev:M 04.12.02 Revised procedural steps KJ/JLM

Additional Product

Job Number:



Seq. #: Machine Or Operation: Description :

1.0 D2620 Bent 206 Skidtube



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Pick:

Qty Part Number Description Batch

1 D2620 Bent Tube 3" OD B2447 DP 05-12-14 ①

2.0 D32861 Doubler



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pick:

Qty Part Number Description Batch

2 D3286-1 Doubler B24206 BE 06-01-03 ①

3.0 D2647 Cap



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Pick:

Qty Part Number Description Batch

1 D2647 Fwd Cap B20535 BE 05-12-19 ①

4.0 LANDING GEAR 1 LANDING GEAR RESOURCE 1



Comment: LANDING GEAR RESOURCE 1

1-Deburr Fwd edge of tube

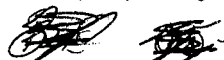
DP 05-12-14 ①

2- Remove ridge on inside of Fwd edge of tube as per Dwg D2650

DP 05-12-14 ①

3-Weld Fwd Cap as per Dwg D2650. Use aluminum rod. Grind D2647 to fit as required:

Pick:



W/O:		WORK ORDER CHANGES					
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Description:

Qty Part Number Description Batch

A/R Aluminum Rod M15855 / m18901 BE 05-12-19 ①

4-Grind weld flush to cap on top surface only. BE 05-12-19 ①

5-Cut Aft end as per dwg 2650 from front of tube and Deburr DP05-12-22 ①

6-Remove inner indexing ridge on Aft end of skidtube as per Dwg D2650 BE 05-12-23 ①

7-Open holes for Aft end cap as per Dwg D2650 with #30 Drill Bit using DT8025. BE 05-12-23 ①

8-Locate DT8732 from inner Aft saddle hole & 3rd crossbolt hole. Insert D3286-1 doubler using DT8732 & D206-642-241-T1, then locating doubler off of 3/16" holes, cleco DT8732 & doubler leaving DT8732 for added support. BE 06-01-03 ①

9- Drill D3286-1 doubler rivet holes in tube using # 40 drill, spot drilling doubler at the same time. BE 06-01-03 ①

10-Working from the center out, drill # 30 holes into D3286-1 doubler. Cleco each hole as it is being drilled. Verify angle of holes to accommodate rivet heads. BE 06-01-03 ①

11-Remove and Deburr D3286-1 doubler BE 06-01-03

12-Remove 3/16" cleco's only and open GHW holes to Ø0.500" as per Dwg D2650 BE 06-01-03 ①

13-Remove D3286-1 doublers, identify orientation, deburr, then attach them to the workorder BE 06-01-03 ①

14-Remove indexing edge using DT8741 as per Dwg D2650 BE 06-01-11 ①

15-C'sink GHW rivet holes as per Dwg D2650 BE 06-01-17 ①

5.0

QC6

DIMENSIONAL CHECK



Comment: DIMENSIONAL CHECK

6.0

LANDING GEAR 1

LANDING GEAR RESOURCE 1



Comment: LANDING GEAR RESOURCE 1

1-Open crossbolt holes to Ø0.3125" as per Dwg D2650 BE 06-01-19 ①

2-Drill pilot holes using DT8028-3, then open to Ø0.297" as per Dwg D2650. Open Aft cap hole #6. BE 06-01-19 ①

3-Deburr tube and blow out chips from inside the tube BE 06-01-19 ①

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Job Number:



Seq. #:

Machine Or Operation:

Description :

7.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

Q.M. 06-01-19 (1)

8.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

~~06-01-19~~ *06-01-20*

9.0

LANDING GEAR 1

LANDING GEAR RESOURCE 1



Comment: LANDING GEAR RESOURCE 1

1-Open holes to finished size as per Dwg D2650, D2650-3 Drilling Detail (without cutting fluid)

BE 06-01-20 (1)

2-C'sink crossbolt spacer holes as per Dwg D2650(without cutting fluid)

BE 06-01-20 (1)

3-Deburr and blow out all chips from inside the tube

BE 06-01-20 (1)

10.0

QC6

DIMENSIONAL CHECK



Comment: DIMENSIONAL CHECK

06-01-20

11.0

CR3212404

Cherry Rivet



Comment: Qty.: 52.0000 Each(s)/Unit Total : 52.0000 Each(s)

Pick:

Qty Part Number Description Batch

52 CR3212-4-04 Rivet

m18491 Pm 06-01-20

12.0

D26543

206 I-Beam (Web)



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Pick:

Qty Part Number Description Batch

1 D2654-3

Web

B24498 Pm 06-01-24 (1)

13.0

LANDING GEAR 1

LANDING GEAR RESOURCE 1



Comment: LANDING GEAR RESOURCE 1

1-Locate, install and rivet doublers as per Dwg D2650. Micro-shave rivets as required

Pm 06-01-20 (1)

W/O:		WORK ORDER CHANGES						
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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Job Number: 25086A

Part Number: D206642241

Job Number:



Seq. #:

Machine Or Operation:

Description :

2-Bond D2654-3 web in place as per QSI 015. Ensure holes line up. Allow 12 Hrs. cure time before cutting

Start Date: 06-01-24 Time: 9:00

Finish Date: 06-01-26 Time: 7:30

Pick:

Qty Part Number Description Batch

A/R Sikaflex-291 M19597

Sikaflex expire date: 06-06-20

Pm 06-01-24 (1)

14.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

06-01-26

15.0

D2649

Crossbolt Spacer



Comment: Qty.: 18.0000 Each(s)/Unit Total: 18.0000 Each(s)

Pick:

Qty Part Number Description Batch

18 D2649 Crossbolt spacer *B24200 BE 06-01-30 (1)*

16.0

D32863

Spacer



Comment: Qty.: 2.0000 Each(s)/Unit Total: 2.0000 Each(s)

Pick:

Qty Part Number Description Batch

2 D3286-3 Spacer *B23932 BE 06-01-30 (1)*

17.0

LANDING GEAR 1

LANDING GEAR RESOURCE 1



Comment: LANDING GEAR RESOURCE 1

1-Insert D2649 crossbolt spacers. Weld as per QSI 004 and Dwg D2650. Remember to back drill each hole to 0.25" before welding the other side. Use aluminum rod.

Pick:

Qty Part Number Description Batch

A/R Aluminum Rod *M15855 BE 06-01-30 (1)*

2-Grind welds flush as per Dwg D2650. *BE 06-01-30 (1)*

3-Counterbore 5/16" x 0.750" deep except 7th hole from Aft end as per Dwg D2650. Deburr *Pm 06-02-03 (1)*

4-Using DT8733, insert (2) D3286-3 spacers as per QSI 004 and Dwg D2650. Remember to back drill each

W/O:		WORK ORDER CHANGES						
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Job Number: 25086A

Part Number: D206642241

Job Number:



Seq. #:

Machine Or Operation:

Description :

hole to Ø0.402" before welding other side. Use SS rod as required.

A/RSS Rod NONE

BE 06-02-03 (1)

18.0

CCR264SS33

Cherry Rivet



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pick:

Qty Part Number Description Batch

2 CCR264SS3-3 Rivets m18548

Pm 06-02-07 (1)

19.0

M7885343

Rivet



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pick:

Qty Part Number Description Batch

2 M7885/3-4-3 Rivets m7808

Pm 06-02-07 (1)

20.0

D2680041

Nut Plate



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Pick:

Qty Part Number Description Batch

1 D2680-041 Nut Plate B21103

Pm 06-02-07 (1)

21.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Install D2680-041 Nut Plate as per Dwg D2650

Pm 06-02-07 (1)

22.0

QC5/9

WELD INSPECTION



Comment: Inspect weld and Counterbore work to Current Step . Inspect for foreign objects as per QSI 024

06-02-08

PD 06-02-07

23.0

POWDER COATING

POWDER COATING



Comment: POWDER COATING

Powder Coat White Gloss (Ref. 4.3.5.1) as per QSI 005 4.3. Make sure Nut Plate Thread is protected using 06-03-01 paint screw, and mask GHW studs.

W/O:		WORK ORDER CHANGES						
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Job Number: 25086A

Part Number: D206642241

Job Number:



Seq. #:

Machine Or Operation:

Description :

24.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

25.0

D26483

Wearpad



Comment: Qty.: 5.0000 Each(s)/Unit Total : 5.0000 Each(s)

Pick:

Qty Part Number

Description

Batch

5 D2648-3

Wearpad

B241843

FC 06 03 08

26.0

D265613

Wearplate



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Pick:

Qty Part Number

Description

Batch

1 D2656-13

Wearshoe

D25329

FC

27.0

D265621

Wearplate



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Pick:

Qty Part Number

Description

Batch

1 D2656-21

Wearshoe

B20532

FC

28.0

D265633

Wearplate



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Pick:

Qty Part Number

Description

Batch

1 D2656-33

Wearshoe

B20756

FC

29.0

D34291

WEARPAD



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Pick:

Qty Part Number

Description

Batch

1 D3429-1

Wearpad

B24117

FC 06 03 08

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

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Job Number: 25086A

Part Number: D206642241

Job Number:



Seq. #:

Machine Or Operation:

Description :

30.0

ALS41032130

Insert



Comment: Qty.: 44.0000 Each(s)/Unit Total: 44.0000 Each(s)

Pick:

Qty Part Number

Description

Batch

44 ALS4-1032-130

Inserts m18293

or (see QSI 017)

FC

31.0

AN960JD10L

Washer



Comment: Qty.: 44.0000 Each(s)/Unit Total: 44.0000 Each(s)

Pick:

Qty Part Number

Description

Batch

44 AN960JD10L

Washer m19185

FC

32.0

MS27039108

Screw



Comment: Qty.: 44.0000 Each(s)/Unit Total: 44.0000 Each(s)

Pick:

Qty Part Number

Description

Batch

44 MS27039-1-08

Screw m16941

FC

33.0

D26511

Plug



Comment: Qty.: 18.0000 Each(s)/Unit Total: 18.0000 Each(s)

Pick:

Qty Part Number

Description

Batch

18 D2651-1

Plugs B25010

FC

34.0

D26513

O-Ring



Comment: Qty.: 18.0000 Each(s)/Unit Total: 18.0000 Each(s)

Pick:

Qty Part Number

Description

Batch

18 D2651-3

O-Rings B23491

FC 06 03 08

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

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Job Number:



Seq. #:

Machine Or Operation:

Description :

35.0

MS27039406

Screw



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Pick:

Qty Part Number Description Batch

1 MS27039-4-06 Screw m6874

FC

36.0

AN960JD416

Washer



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Pick:

Qty Part Number Description Batch

1 AN960JD416 Washer m11151

FC

37.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1]

1- Install inserts & wearpads as per dwg D2922. Use a drop of Sikaflex inside insert holes before installing wearpad/wearplate.

A/R Sikaflex-291 m19597
Sikaflex expire date: 06 18 06

FC

2-Install D2651-3 O-Rings on D2651-1 plugs with Petroleum Jelly and install plugs as per Dwg D2650. FC
Clean excess adhesive.

3-Install MS27039-4-06 Screw as per DEO 9153. FC

38.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

Inspect for foreign objects as per QSI 024

FC

39.0

D2646

Aft Cap



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Pick:

Qty Part Number Description Batch

1 D2646 Aft Cap 020208

FC 06 03 08

Dart Aerospace Ltd

WORK ORDER CHANGES									
W/O:	DATE	STEP	PROCEDURE CHANGE			By	Date	Qty	Approval Chief Eng / Prod Mgr

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes ☒ No ☐ DQA: ☒ Date: 6/13/13
 QA: N/C Closed: _____ Date: _____

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Job Number:



Seq. #:

Machine Or Operation:

Description :

40.0

MS27039108

Screw



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pick:

Qty Part Number Description Batch

2 MS27039-1-08 Screw m 169411

FC

41.0

AN960JD10L

Washer



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pick:

Qty Part Number Description Batch

2 AN960JD10L Washer m 19185

FC

42.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

1-Install D2646 Aft Cap and seal with Sikaflex. Clean excess adhesive

A/R Sikaflex-291 m 14597

Sikaflex expire date: 06 18 06

FC

06 08 08

2-Wing Walk as per Dwg D2650-3 and QSI 005 4.4

Batch: M10037

FC

06 03 08

43.0

QC3/5

INSPECT WORK/WING WALK



Comment: INSPECT WORK/WING WALK

m

06 03 08 ①

44.0

DC

DOCUMENT CONTROL



Comment: DOCUMENT CONTROL

Inspection Level 21

① 06/03/13

Job Completion



u 06-03-10

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